

Friday, February 13, 2015 12:46:01 PM

Page 1

110		0.00			
110					
Cold Saw	Memo	0.00			
Hyd Mech	CUT TO BLANK				
120	Manufacture as per dwg	0.00			
120					
Mill Conv	Memo	0.00			
Conventional Milling Machine	DRILL HOLES AND MILL ENDS AS PER DWG				
130	QC2- Inspect parts off machine FAI/FAIB	0.00			
130					
QC	Memo	0.00			
Quality Control					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____ _____
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Page 2

Friday, February 13, 2015 12:46:01 PM

Reference:

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

DQA: _____ Date: _____



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Work Order ID 129558

Friday, February 13, 2015 12:46:01 PM

129558

Page 3

Item ID: D5159-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Rib
Start Date: 2/13/2015 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 2/20/2015 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Stamp
170	Identify as per dwg & Stock Location: Stsok	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21 - Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

DIS-2-27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Picklist Print

Friday, February 13, 2015 12:46:01 PM

Page 1

Work Order ID: 129558

129558

Parent Item: D5159-1

D5159-1

Parent Item Name: Rib

Start Date: 2/13/2015

Required Date: 2/20/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 14.10.03 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.049		Purchased	No				f	1,091.067		8		DAS 37 9-89	DAS 37 9-89
M304TS0 750W 049										**			
304 SQ Tube .75x.75x.049W													
												15.02.18	

Location

Loc Qty

Loc Code

WA004

1091.067

M130871

510.9

M131128

580.167

BSE.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

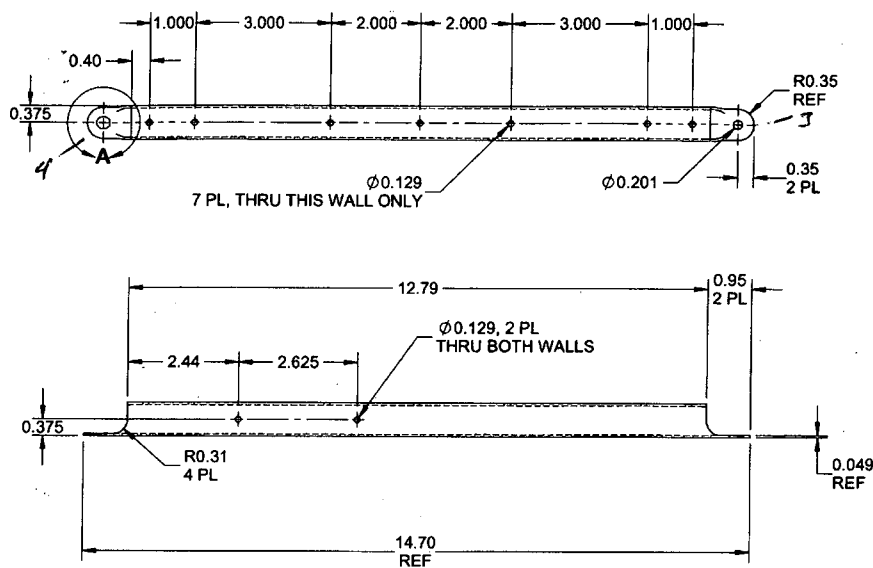
Work Order update only ☐

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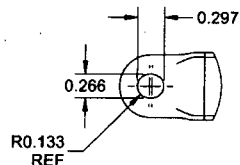
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FAULT CATEGORY

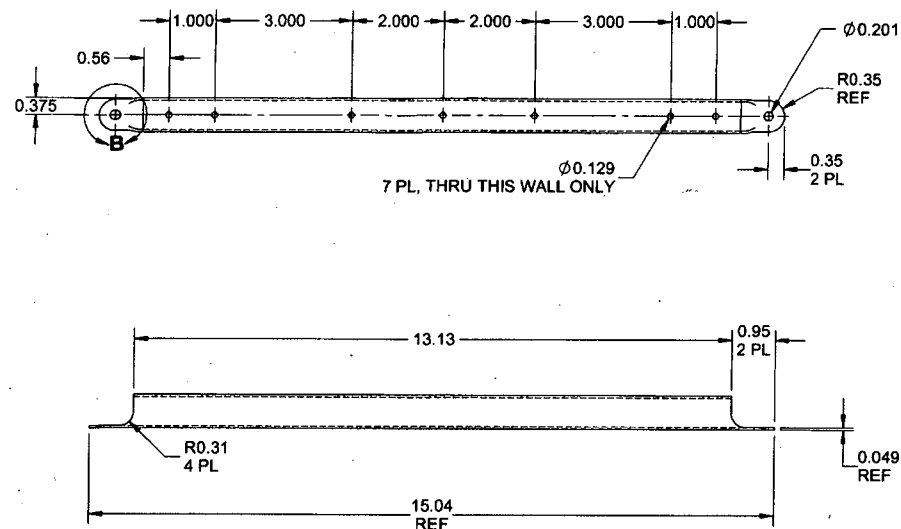
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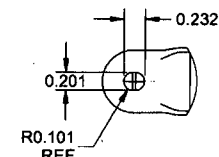
D5159-1 RIB



DETAIL A
SCALE 2X



D5159-3 SEAT RIB



DETAIL B
SCALE 2X

RELEASED

2015 FEB 04

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
PER ASTM A554/A269 MILL FINISH
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.49 lbs
-3: 0.50 lbs

APPROVED

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	DD	D5159	SHEET 3 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	SEAT BRACE ASSY	NTS
DATE	14.09.24	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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DART AEROSPACE LTD		Work Order: 129558
Description: R13		Part Number: 5159-1
Inspection Dwg: 5159 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
φ.129	+ .005 - .001	.129	-		DR16	8" VERN
φ.201	+ .005 - .001	.203	-			
.35	± .030	.349	-			
.375	± .010	.372	-			
.40	± .030	.401	-			
1.000	± .010	1.00	-			
3.000	± .010	3.000	-			
2.000	± .010	2.000	✓			
2.000	± .010	2.000	✓			
3.000	± .010	3.000	✓			
1.000	± .010	1.000	✓			
12.79	± .030	12.79	-			
14.70	± .030	14.69	-			
.95	± .030	.940	✓			
2.44	± .030	2.44	✓			
2.625	± .010	2.625	✓		DR16	8" VERN
.266	± .010	.269	-		"	"
.297	± .010	.299	-		"	"

Measured by: DAS 37		Audited by: DAS 44		Preliminary Approval:	
Date: 15.02.18		Date: 15/02/24		Date:	

Rev	Date	Change	Reviewed by	Approved
E	10.04.14	Added preliminary approval	KJ	

A 10.04.15